



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D3913-041
Job Sheet 187909



Part No: D3913-041

Job Qty: 1 ea

Part Name: Long Basket Base Assembly, 350



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 12/20/18

Job Tracking No:

Due Date: 1/4/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG D4020 REV A SHEET 4, D3913 REV D SHEETS 1,2,3,4,5 IPP Rev:A new issue DD 10.03.19 verified by:EC IPP Rev:B chg qty's DD 10.04.12 verified by:EC IPP Rev:C 12.07.24 AS PER DWG REV.B DD VERF:EC IPP REV:D 13.08.21 DWG REV.C / ECN 13-624 DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea		1/4/19	0.00	0.00	Start Up Large Fab-5		CC
100	Large Fab	1 pcs		1/4/19	0.00	10.00	Large Fab 1		CC
110	QC	1 pcs		1/4/19	0.00	0.00	QC9		MA
120	QC	1 pcs		1/4/19	0.00	0.00	QC5		MA
125	HandFinish	1 pcs		1/4/19	0.00	0.29	HandFinish2		BR 19-01-10
130	Powdercoat	1 pcs		1/4/19	0.00	0.93	Powdercoat2		BR 19-01-10
135	Packaging	1 pcs		1/4/19	0.00	0.00	Packaging1		BE 13 19-01-11
140	QC	1 pcs		1/4/19	0.00	0.00	QC3		BE 13 19-01-11
150	HandFinish	1 pcs		1/4/19	0.00	0.50	HandFinish4		BE 13 19-01-11
160	QC	1 pcs		1/4/19	0.00	0.00	QC5		DAS 21 JAN 11 2019 68
170	Packaging	1 pcs		1/4/19	0.00	0.00	Packaging3-2		DAS 21 JAN 2 9-89
180	QC21-SA	1 Ea		1/4/19	0.00	0.00	QC21		21

Part Op 100 - 1- assemble ribs , weld as per dwg D3913 using DT9610A ***inspect before welding mesh*** 2-Cut D4020-1 base
Descriptions: mesh and tack weld all mesh on basket as per dwg D3913 and trim mesh to fit if necessary and trim to clear fasteners
holes on the ends 3- weld hinge (3) and Mounting brackets as per dwg D3913 ***take lid to locate hinge and bracket*** 4-
Weld D4672-1 blanking plates as per dwg
130 - 1- Plug holes and mask only interior of hinge (3) prior to powder coat
150 - Pick Kit

M 138951 START: 3:55 OUT: 3:75 FINISH: 4:10

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2581 ✓	Mounting Bracket	2 pcs (2 ea) ✓	90-Start up Operation	5125289
D3913-1 ✓	Rib	1 Ea (1 ea) ✓	90-Start up Operation	5138226
D3913-15 ✓	Wide Handle Plate	1 pcs (1 ea) ✓	90-Start up Operation	5115269
D3913-3 ✓	Rib	1 Ea (1 ea) ✓	90-Start up Operation	5124101
D3913-7 ✓	Rib	2 Ea (2 ea) ✓	90-Start up Operation	5136111
D3913-9 ✓	Hinge Rib	1 Ea (1 ea) ✓	90-Start up Operation	5139177
D3916-041 ✓	Rib Assembly	2 Ea (2 ea) ✓	90-Start up Operation	5138851
D3916-5 ✓	Light Rib	3 Ea (3 ea) ✓	90-Start up Operation	5141287
D4016-1 ✓	Hinge Half, Base	3 pcs (3 ea) ✓	90-Start up Operation	5115309
D4017-7 ✓	Rib	3 pcs (3 ea) ✓	90-Start up Operation	5123991
D4017-9 ✓	Rib	2 pcs (2 ea) ✓	90-Start up Operation	5134676

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Cross tube ☐</td> <td>Eng. (Non-AW) ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Water Jet ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Supplier Quality ☐</td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Eng. (Non-AW) ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Water Jet ☐	Large Fab ☐	Finishing ☐	Rec/Store/Packaging ☐	Supplier Quality ☐																																
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D4020-11	End Mesh, Basket	2 Ea (2 ea)	90-Start up Operation	5133427
D4021-1	Handle Plate	3 pcs (3 ea)	90-Start up Operation	5126559
D4034-041	Aft Upper Rib Assembly	1 Ea (1 ea)	90-Start up Operation	5138258
D4034-043	Fwd Upper Rib Assembly	1 Ea (1 ea)	90-Start up Operation	5138521
D4672-1	Blanking Plate	2 pcs (2 ea)	90-Start up Operation	5126705
M304EX0.75-16F	Expanded Metal Flat SS	33 sf (33 ea)	90-Start up Operation	5109214
AN3-10A	Bolt	6 Ea (6 ea)	150-HandFinish	5106952
D2931	Bumper	2 pcs (2 ea)	150-HandFinish	F86435
MS20600-AD4W3	Cherry Rivet	2 Ea (2 ea)	150-HandFinish	5076007
MS21042L3	Nut	6 Ea (6 ea)	150-HandFinish	5094592
NAS1149F0332P	Washer	12 Ea (12 ea)	150-HandFinish	5133206-1
D4021-5	Blanking Plate	2 pcs (2 ea)	150-HandFinish	5118039
NAS1149FN832P	Washer	2 Ea (2 ea)	150-HandFinish	5136368-1

M.U.007446.

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D2581	2	27	0
	D3913-1	1	6	0
	D3913-15	1	6	0
	D3913-3	1	9	0
	D3913-7	2	8	0
	D3913-9	1	9	0
	D3916-041	2	8	0
	D3916-5	3	9	0
	D4016-1	3	183	0
	D4017-7	3	20	0
	D4017-9	2	6	0
	D4020-11	2	13	0
	D4021-1	3	19	0
	D4034-041	1	5	0
	D4034-043	1	5	0
	D4672-1	2	12	0
	M304EX0.75-16F	33	1,599	0
150-HandFinish	AN3-10A	6	305	0
	D2931	2	843	0
	D4021-5	2	13	0
	MS20600-AD4W3	2	255	0
	MS21042L3	6	2,808	0
	NAS1149F0332P	12	2,678	0
	NAS1149FN832P	2	2,343	0

Part Specifications

Specifications could not be found.

Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

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Part: D3913 - 041
Job No: 187909
Serial No/Batch: S143325
Revision:
Inspector:
Exp Date:
Instructions: Various STC's

Date: 01/09/19

Container No: S143325
Part: D3913 - 041
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DART
AEROSPACE

Engineering ☐
Water Jet ☐
Supplier ☐
Quality ☐

MRB (QS1042)

Completed By _____

Hand / Supervisor _____

QC / QA Coordinator _____